Qty:

User:

Tuesday, 31/03/2009 1:04:21 PM Julie Dawson

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: STOP

Job Number

: 46736

**Estimate Number** P.O. Number

: 10513

: //

: 46314

: 31/03/2009 S.O. No. : Part Number

: D28052

: NC

Type

**Drawing Number** 

- D2805 REV. B

Project Number

: N/A

**Drawing Revision** 

: B

Material

Due Date

: 07/04/2009

20 Um:

Each

Written By

This Issue

Prsht Rev.

First Issue

Previous Run

: MACHINED PARTS

Checked & Approved By Comment

B 00.11.14 : Est:

Revised Finishing step to Acid etch and

Alodine EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M6061T6B1500X01500

6061-T6 Bar 1.50 x 1.50



Comment: Qty.: 0.2756 f(s)/Unit

Total: 5.5125 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" 1.5" x 1.5" 1.5" Alach: M6061T6B1500X01500) Batch: M169862

(M6061T6B1500X01500)

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut Bar: 3.150" Long

+0.010/-0.030"



3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1







Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Machine as per Folio FA104 and Dwg D2805
- 2- Tumble and Deburr

Identify as D2805-2



4.0

QC2



09/04/63





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

OC8

SECOND CHECK



Comment: SECOND CHECK





Dart	<b>Aeros</b>	pace	Ltd
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		— - <del></del>				-			
W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Ye	es No Do	QA:	Date: _	
	Resolution: Disposition: QA: N/C C								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)	· · · · · ·		
DATE	STEP	Description of NC				Verification Ann			Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Approval Chief Eng	QC inspector
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		- /				1			

NOTE: Date & initial all entries

Tuesday, 31/03/2009 1:04:21 PM Date: Julie Dawson User: **Process Sheet** Sustomer: CU-DAR001 Dart Helicopters Services **Drawing Name: STOP** Part Number: D28052 Job Number: 46736 Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 **Comment: INSPECT ALODINE** PACKAGING RESOURCE #1 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_\_ 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace
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W/O:			WC	RK ORDER CHANG	iES				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-									
					:	1			
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No DO	QA:	Date:	
		Resolution: Disposition: QA: N							
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NO	R)			
DATE	STEP	Description of NC	Description of NC Corrective Action Section			Verif	ication	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	ı&∣ <sub>Sec</sub>	Section C	Chief Eng	QC Inspector
							······································		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	H6736
Description: Stop	Part Number:	D2805-2
Inspection Dwg: D2805 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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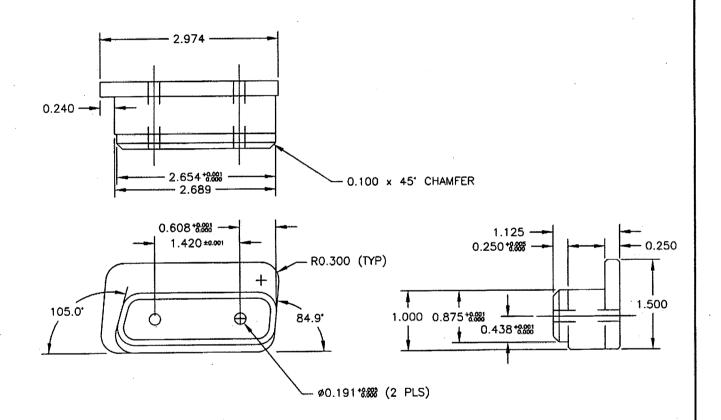
Drawing	Talanana	Actual		Dairest	Method of	0
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
2.974	+/-0.010	2.974	<i>\'</i> ,			
0.240	+/-0.010	0.240	1			-
0.100 chamfer	+/-0.010	0.095		,^		
1.420	+/-0.001	1.420	<i>J</i> ,			
1.125	+/-0.010	1.128		·		
0.250	+0.005/-0.000	0.2515	<b>\</b>			
0.250	+/-0.010	0.253				
1.500	+/-0.010	1.496				
1.000	+/-0.010	0.998				
0.875	+0.001/-0.000	0.876	/,			
0.438	+0.001/-0.000	0,438				
				·		
					<u></u>	

Measured by:	Audited by:	- And	Prototype Approval:	N/A
Date: 09/3	Date:	09/04/03	Date:	N/A

Rev	Date	Change	Revised by	Approx/ed
Α	05.04.26	New Issue	KJ/JLM	



DESIG	*	DRAWN BY		SPACE LTD INTARIO, CANADA
CHECK	ED	APPROVED	DRAWING NO.	REV. B
İ	#	-	D2805	SHEET 1 OF 2
DATE			TITLE	SCALE
01.0	3.13		STOP	2:3
Α		00.10.31	NEW ISSUE	
В		01.03.13	ADD -3/-4	



D2805-1 (SHOWN) D2805-2 (OPPOSITE)

**SHOP COPY RETURN TO** ENGINEERING **UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

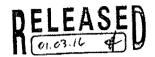
BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

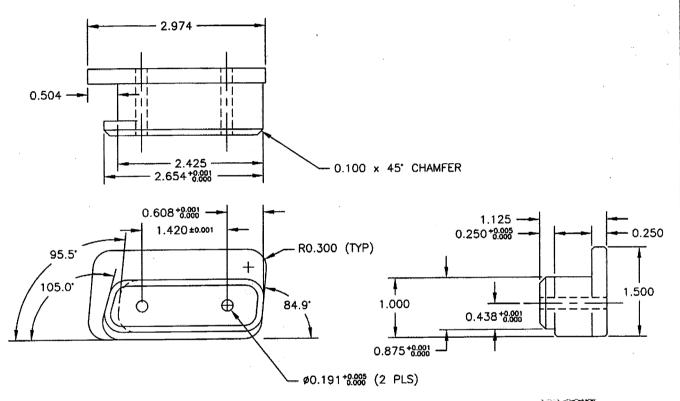
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DESIGN	DRAWN BY		ROSPACE LTD (, ONTARIO, CANADA
CHECKED,	APPROVED	DRAWING NO.	REV. B
df	9#	D2805	SHEET 2 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3





D2805-3 (SHOWN) D2805-4 (OPPOSITE)

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